

Work Order ID 62215

Wednesday, September 22, 2010 11:46:55 A



Page 1

| | | | | | |
|--------------------------|------------------|--|---------------|-------|--|
| Item ID: D3572-3 | Accept | | Setup | Start | |
| Revision ID: | | | | Stop | |
| Item Name: Guide | | | | | |
| Start Date: 9/22/2010 | Start Qty: 10.00 | | Cust Item ID: | | |
| Required Date: 9/29/2010 | Req'd Qty: 10.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|---------------|---------------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: 10-9-12 | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3572 | Rev D | | | | | | | | |

| | | | | | | | | | |
|----------------|----------------------|------|--|-------------|--|--|--|------|--|
| 100 | | 0.00 | | | | | | | |
| | BAND SAW | | | | | | | | |
| Bandsaw | Memo | 0.00 | | | | | | | |
| Jeaspa Bandsaw | Cut blank .500" long | | | 2L 10/10/28 | | | | (10) | |

| | | | | | | | | | |
|------------------------------|--|------|--|----------|--|--|--|----|---|
| 110 | | 0.00 | | | | | | | |
| | HAAS CNC VERTICAL MACHINING #1 | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | 1- Mill as per Folio FA685 Rev: AA & Dwg D3572 Rev: D 2-Deburg per dwg D3572 | | | 10/11/02 | | | | 10 | 0 |

| | | | | | | | | | |
|-----------------|---|------|--|----------|--|--|--|----|---|
| 120 | | 0.00 | | | | | | | |
| | QC2- Inspect parts off machine FAI/FAIB | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | 10/11/02 | | | | 10 | 0 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| Revision ID: | | | | | Stop | |
| Item Name: | Guide | | | | | |
| Start Date: | 9/22/2010 | Start Qty: | 10.00 | | Cust Item ID: | |
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|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------------|
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | 10 | 0 | | |
| 140 | Identify as per dwg & Stock Location: 244 | 0.00 | | | | | | | |
| Packaging Packaging | Memo | 0.00 | | | | | | | 10/11/02 sf 100 |
| 150 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | ck 10/11/02 [Signature] |

MF
10-11-2

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 11:47:00 AM

Page 1

Work Order ID: 62215



Parent Item: D3572-3



Parent Item Name: Guide

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B rev.B dwg EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.750X01.50 0 | | Purchased | No | | | | f | 42.5606 | 0.04 | 0.400200 | | | |



6061-T6 Bar .750 X 1.50



SL 10/10/28

Location

Loc Qty

Loc Code

MAT

2.5606

114415

2.5606

MAT028

40

114968

20

114993

20

41

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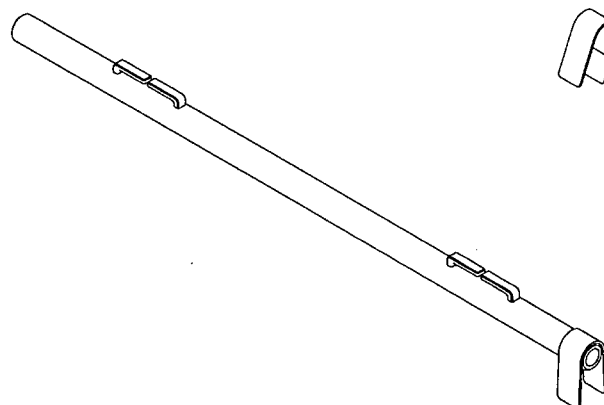
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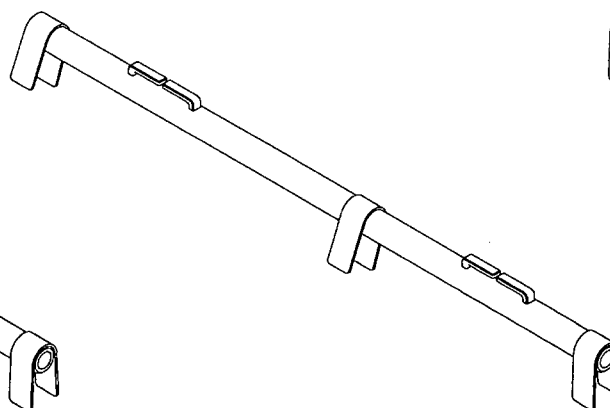
| ITEM No. | QTY -041 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|----------|----------|----------|----------|-------------|-----------------------------|
| 1 | X | | | D3572-041 | GUIDE ASSEMBLY |
| 2 | | X | | D3572-043 | GUIDE ASSEMBLY (UH-1) |
| 3 | | | X | D3572-044 | GUIDE ASSEMBLY (UH-1) (OPP) |
| 11 | 1 | 1 | 1 | D3572-1 | TUBE |
| 12 | 4 | 4 | 4 | D3572-3 | GUIDE |
| 13 | 1 | 3 | 3 | D3572-5 | BRACKET |
| 14 | - | - | - | D3572-7 | DELETED AT REV C |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62215-
BS109-22

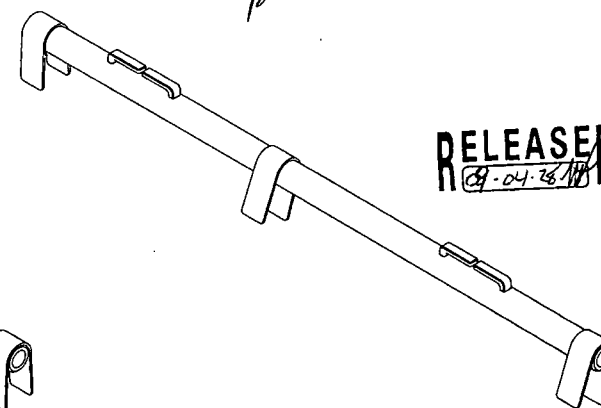
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09-04-28/11



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

| D | REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017. | AJS | 09.04.17 |
|------------|---|--|--------------|
| C | REMOVE D3572-7 | LE | 07.06.01 |
| B | FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET | LE | 07.04.20 |
| A | NEW ISSUE | LE | 07.03.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | CE | DRAWING NO. | REV. D |
| MFG. APPR. | CE | D3572 | SHEET 1 OF 4 |
| APPROVED | CE | TITLE | SCALE |
| DE APPR. | CE | GUIDE ASSEMBLY | NTS |
| DATE | 09.04.17 | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

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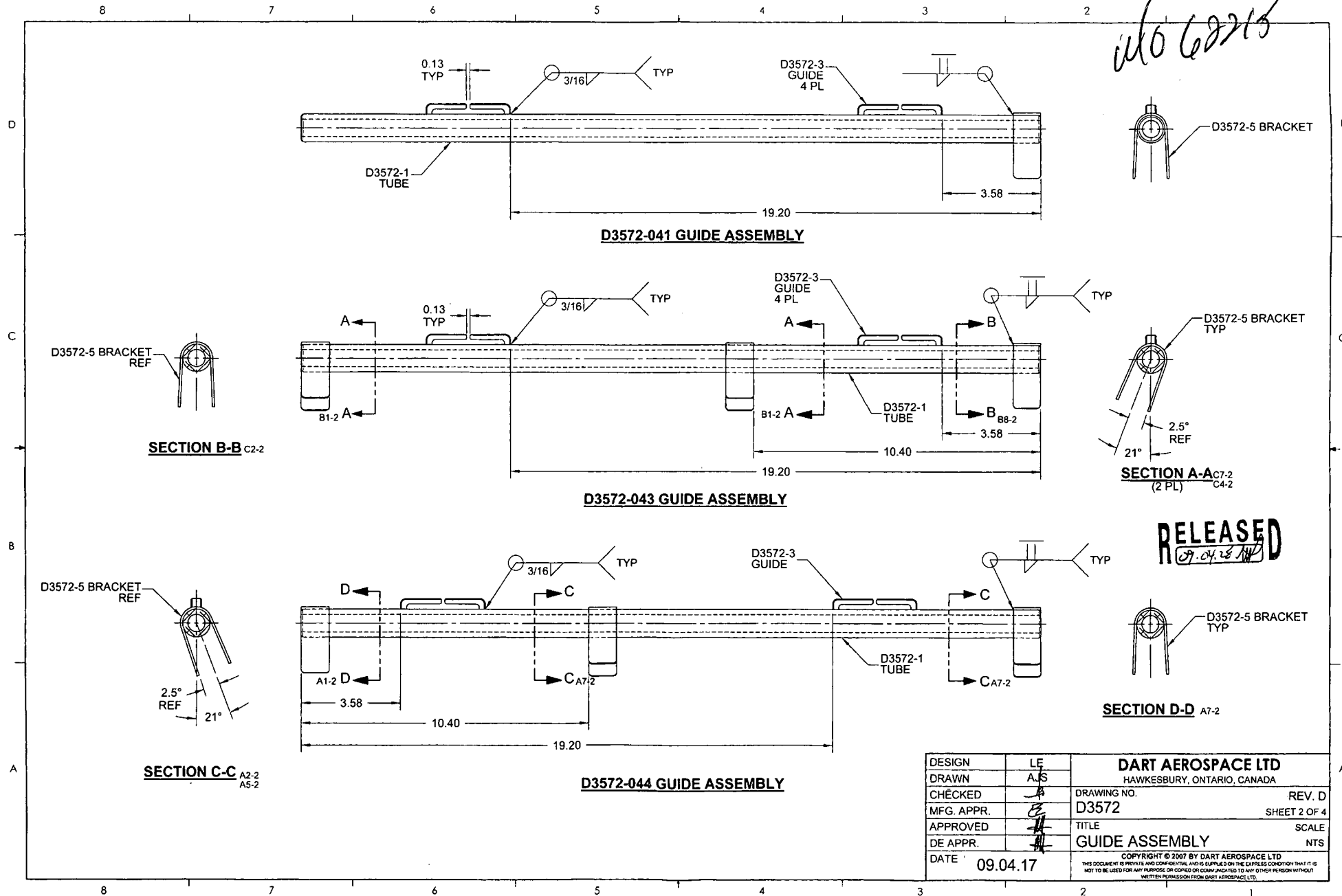
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

into 68215



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| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | B | DRAWING NO. | REV. D |
| MFG. APPR. | E | D3572 | SHEET 2 OF 4 |
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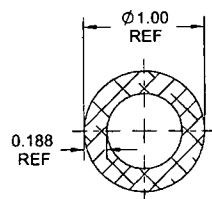
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

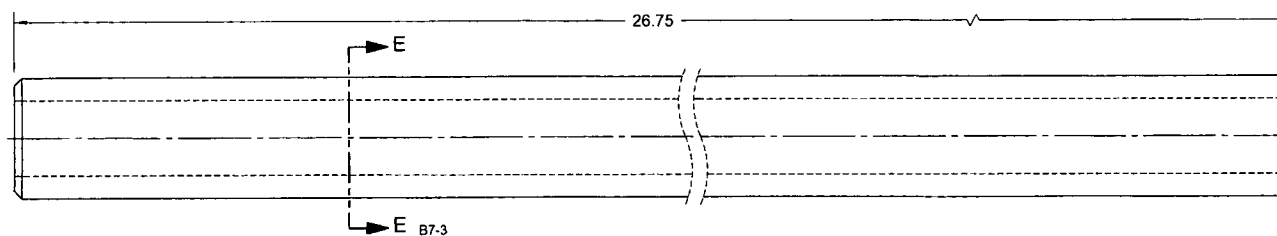
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who 62215



SECTION E-E C5-3







D3572-1 TUBE

0.06 X 45° CMF
MIN

RELEASED
09/04/17 MP

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER VVW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

| | | | |
|------------|---|---|--------------|
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | A/S | | |
| CHECKED |  | DRAWING NO. D3572 | REV. D |
| MFG. APPR. |  | TITLE GUIDE ASSEMBLY | SHEET 3 OF 3 |
| APPROVED |  | | SCALE |
| DE APPR. |  | NTS | |
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NOTE: Date & initial all entries

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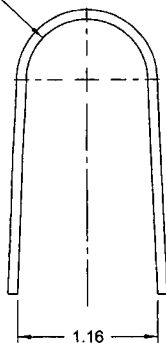
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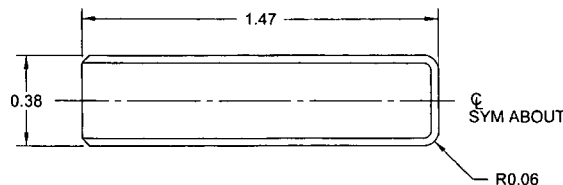
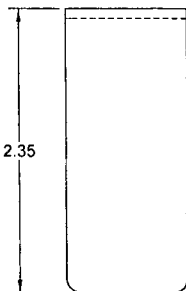
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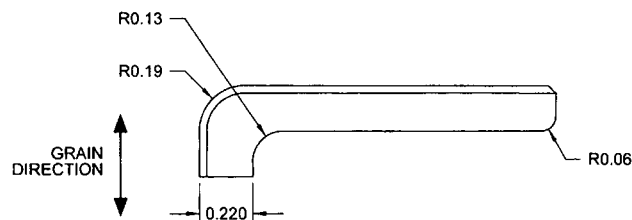
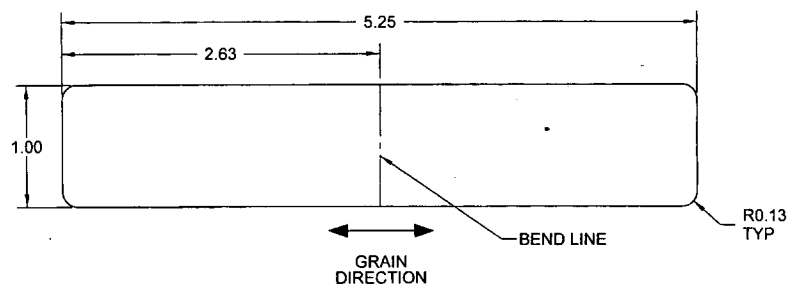
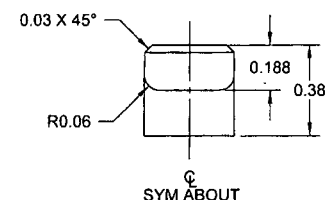
R0.50



2.35

C
SYM ABOUT

R0.06

D3572-5 BRACKET
(MAKE FROM D3572-5F)**D3572-3 GUIDE**C
SYM ABOUT**D3572-5F FLAT PATTERN****RELEASED**
9/04/17**D3572-3 NOTES:**

1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.04 lbs

| | | | |
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| DRAWN | AS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3572 | SHEET 4 OF 4 |
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